

# Work Order ID 56205

February 12, 2010 2:33:12 PM



Page 1

Item ID: D3825-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Basket End)

Start Date: 2/12/10 Start Qty: 6.00



Cust Item ID:

Required Date: 2/18/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: *PL*

Date: *10-2-12*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3825	Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3825-1 rib as per dwg D3825

2- drill hole (3/16") in D3825-1 using DT9438 jig and open to finish size as per dwg D3825

3- c'sink hole as per dwg

4- remove identification markings

5- deburr

*SAD 10-02-16*

6- weld D2327-3 spacer bushing and D3759-1 bushing as per dwg D3825

A/R S.S. Rod Batch: *M109213*

7- grind bushing weld flush where indicated on dwg D3825

8- deburr if necessary

*6*

*10-02-25*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC9- Inspect visual per QS1004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

⑥ 10.02.26

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8.06/26

⑥ +6

150

Identify as per dwg & Stock Location: Basket

0.00



Packaging

Memo

0.00

Packaging

⑥ PD 10.03-01

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

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Customer:

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Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/03  
mf  
10-3-01

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 56205

Parent Item: D3825-041

Parent Item Name: Rib Assembly (Basket End)


Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Start Date: 2/12/10

Required Date: 2/18/10

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2327-3 ✓  Spacer Bushing		Manufactured	No			100	Each	51.0000	6.0000			

*lpl 10.02.25*

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST	13	
44274	4	
44365	9	

Main Warehouse

WA	38	
55167	18	<i>lpl</i>
55917	20	

D3759-1



Bushing

Manufactured No

100 Each 36.0000 6.0000



*lpl 10.02.25*

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

WA	36	
53442	2	
54072	9	
55789	25	<i>lpl</i>

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 56205



Parent Item: D3825-041



Parent Item Name: Rib Assembly (Basket End)

Start Date: 2/12/10

Required Date: 2/18/10

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M304TS0.750W.065

Purchased

No

100

f

462.2112

13.4211



SAD

10-02-15

304 SQ Tube .75x.75x.065W

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

462.2112242

113082

0.00419

113245

0.00038421

113683

16.30855

113836

65.8981

113956

380

13.4211

Main Warehouse

WA

0.0000047

112398

0.0000047

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Shop Packet Print

Page 2

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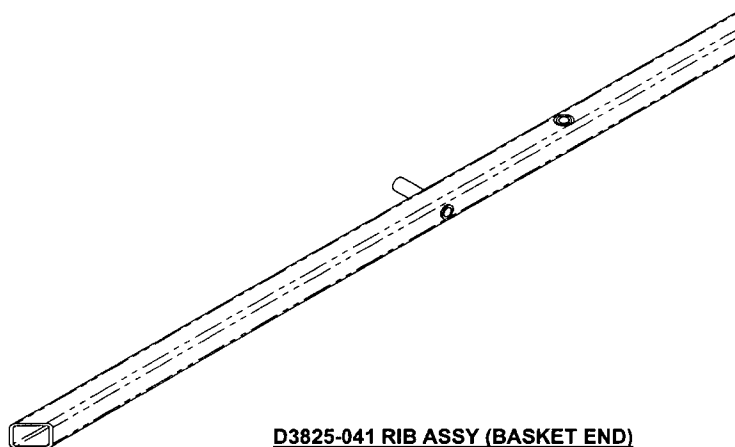
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3825-041	RIB ASSEMBLY (BASKET END)
2	1	D2327-3	SPACER BUSHING
3	1	D3759-1	BUSHING
4	1	D3825-1	RIB



**D3825-041 RIB ASSY (BASKET END)**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 56205

BY 10-2-12

**RELEASED**  
08/11/12

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 1.22 lbs
  - 8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.23		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3825** REV. A  
SHEET 1 OF 3  
TITLE **RIB ASSY (BASKET END)** SCALE NTS

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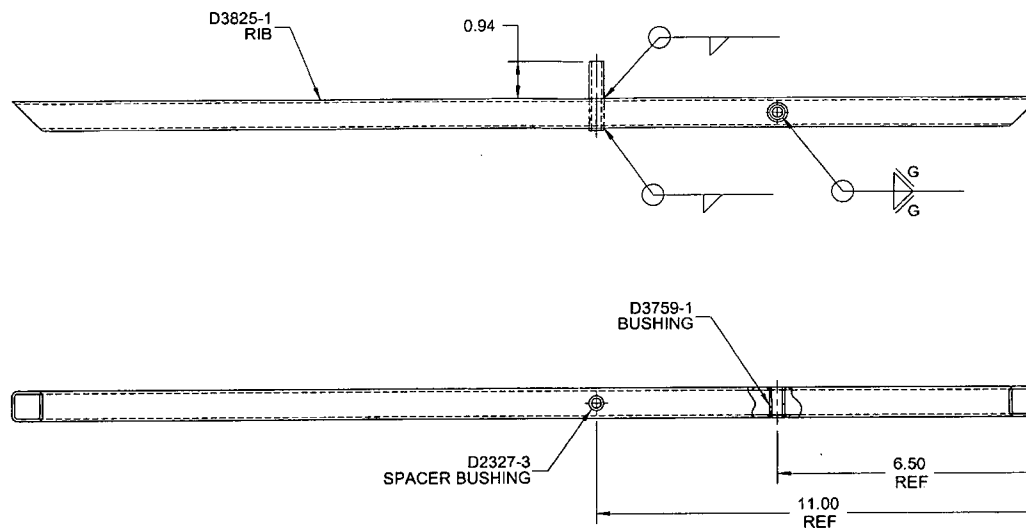
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**D3825-041 RIB ASSY (BASKET END)**

*w/o 56205*

**RELEASED**  
08/11/18 JN

DESIGN		<b>DART AEROSPACE LTD</b>	
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CHECKED	<i>AS</i>	DRAWING NO. <b>D3825</b>	REV. A
MFG. APPR.	<i>M</i>	SHEET 2 OF 3	
APPROVED	<i>W</i>	TITLE <b>RIB ASSY (BASKET END)</b>	SCALE
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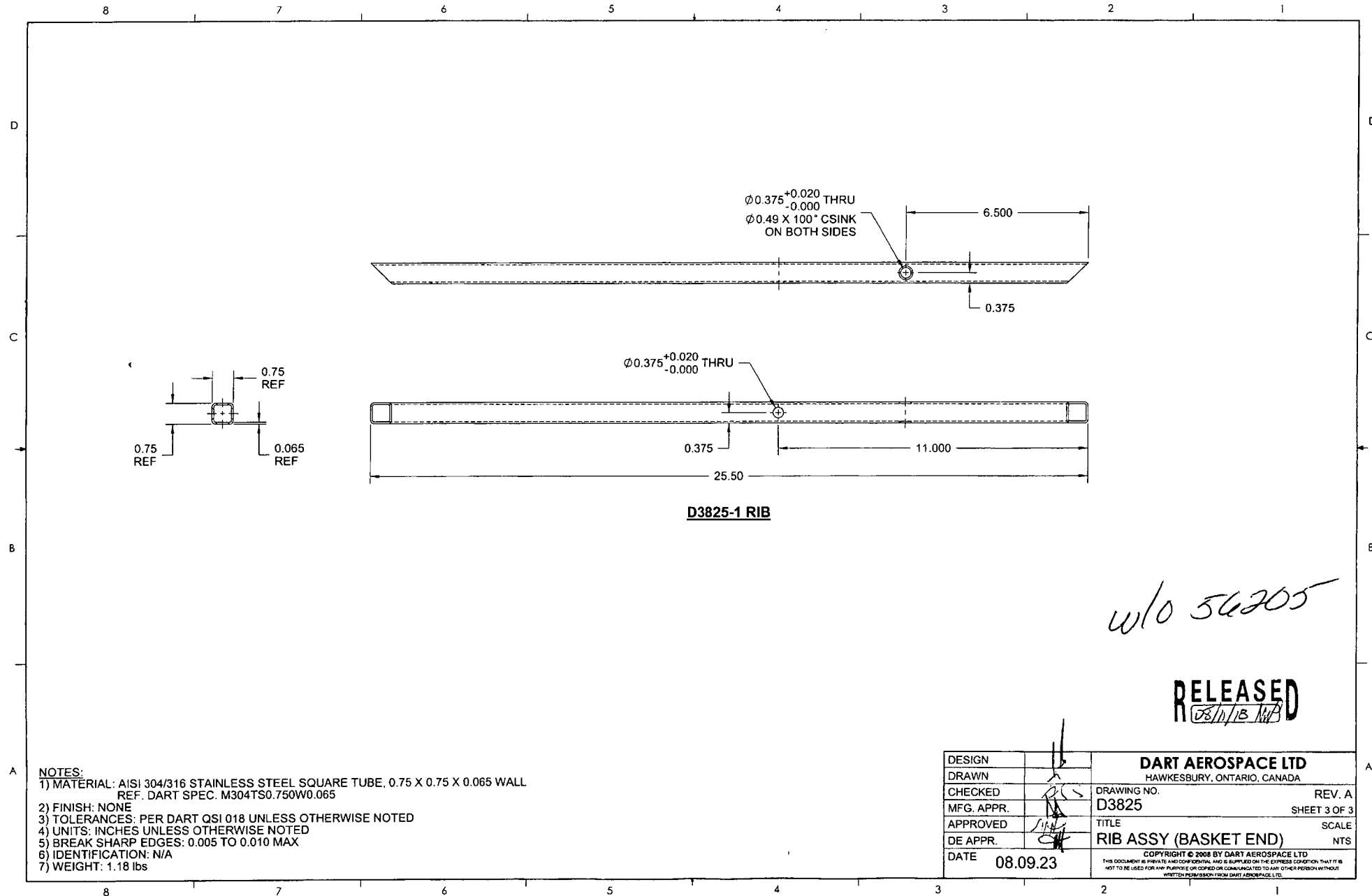
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